

-021 Blue

Dart Aerospace Ltd.

38

Date: Tuesday, 8/21/2007 2:01:00 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L /407 STEP ASSY, LH
Job Number	: 34129A		
Estimate Number	: 11702		
P.O. Number	: NA	Part Number	: D2724041 <i>BL</i>
This Issue	: 8/21/2007	S.O. No.	: NA
Prsht Rev.	: NC	Drawing Number	: D2724 REV C
First Issue	: NA	Project Number	: NA
Previous Run	: 33756A	Drawing Revision	: C
		Type	: LARGE FAB ASSY
		Material	: NA
Written By	:	Due Date	: 9/20/2007
Checked & Approved By	: <i>07.08.21</i>	Qty:	3 Um: Each
Comment	: Est Rev: E As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<i>332858</i>

Check Material for any Dents or Defects

0. m 07.09.10 3

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-1 using D2622 extrusion as per Dwg D2724
Deburr and bevel ends for welding

0. m 07.09.10 3

3.0	D2734	206 Step Endplate
-----	-------	-------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<i>333861</i>

PE. 07.09.11

4.0	D34581	PLATE
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3458-1	Plate	<i>334179</i>

PE. 07.09.11 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 2:01:00 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 34129A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34583

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3458-3

Plate

334180

16 07.09.11

3

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by Jig

DT (One End Only)

A/R AL ROD Batch:

M103794

M104721

16 07.09.11

3

Grind end cap welds flush

R.M

01.09.13

3

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

207/09/13 (3)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 07/09/13 (3) (3LH)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

4.1 07.09.13

3

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 07/09/17 (3X)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

16 07.09.18

3

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 2:01:00 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 34129A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig
DT
A/R AL ROD Batch: M103794

Grind per dwg D2724

a.m 07.09.20 3

LE 27.09.18 3

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-09-20 (3)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/20 (3) 3LH

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

(3) 3LH

Touch up Alodine

BL 07-09-20

15.0

SPRAY PAINTING

SPRAY PAINTING



Comment: Issue P.O. 4650
Atelier Debosselage

C207/09/21

3

07/17/24 (3)

Spray Paint Delfleet Blue
Clear with Delfleet

16.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

En 07/09/25 (3) 3LH

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

M105694

FL 07/09/25 (3)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/17/24 (3)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 21/06/16

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 2:01:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 34129A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PP

34129

8/21/26

(3)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

Done 8/21/06

Job Completion



u 070926

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

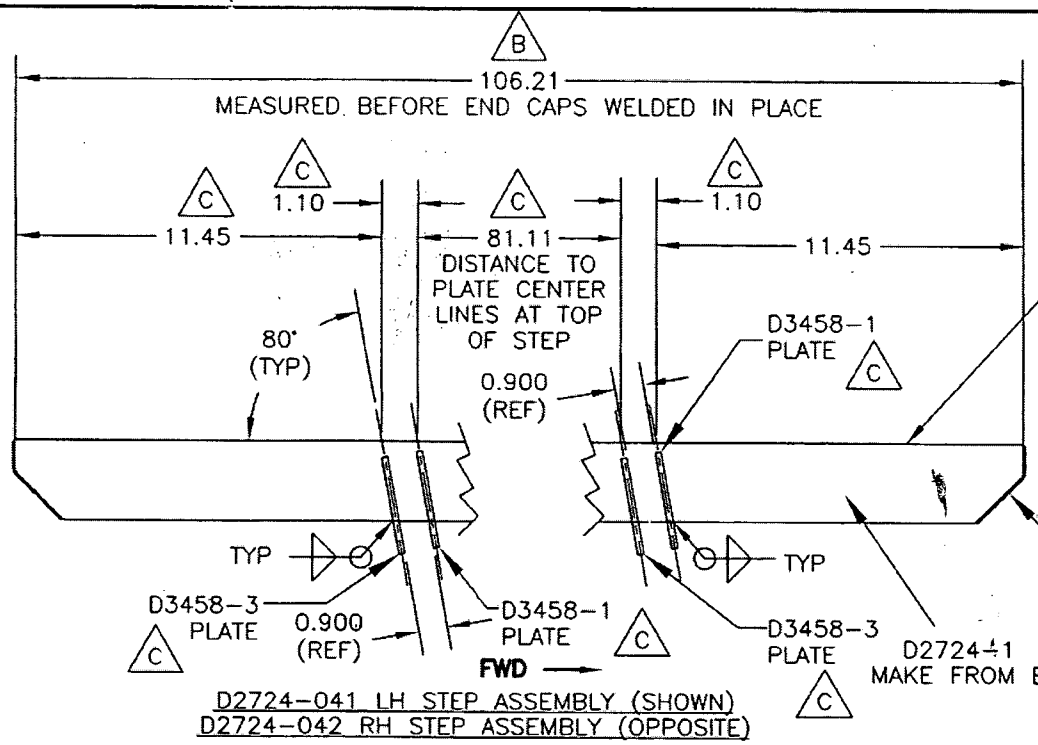
NOTE: Date & initial all entries



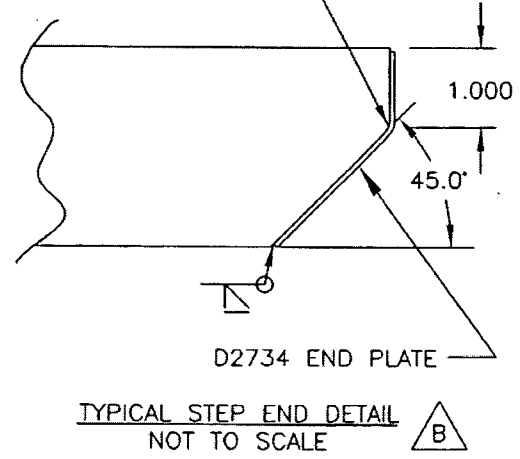
RELEASED
05.11.14

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
KE	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2724	SHEET 1 OF 1
DATE		TITLE	SCALE
05.09.19		206L/407 STEP ASSEMBLY	NTS
A	97.12.04	NEW ISSUE	
B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES	
C	05.09.19	RE-DESIGN, ADD D3458-1/-3	

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
34122A

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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